

Date:
User:Thursday, 05/02/2009 3:47:47 PM
Julie Dawson

Process Sheet

Split for order
X2

JWS

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 45578 -2

Estimate Number : 13593

P.O. Number :

This Issue : 05/02/2009 S.O. No. :

Prsht Rev. : NC

First Issue : // Type : SMALL /MED FAB

Previous Run :

Written By :

Checked & Approved By: JWS 09.02.04

Comment : Est Rev:A 08-09-18 new issue DD verified by:ec

Drawing Name : SPACEPOD FLOOR LH

Part Number : D3798041

Drawing Number : D3798 REV A

Project Number : N/A

Drawing Revision : A

Material :

Due Date : 28/02/2009

Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 M6061T6S050

6061-T6 .050 Sheet



B 9-2-27



Comment: Qty.: 9.2334 sf(s)/Unit Total : 36.9335 sf(s)

6061-T6 .050 Sheet 17347x3 =

Batch: 110791x2 =

2.0 WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

Cut as per Dwg D3798-1

Dwg Rev: A

Prog Rev: A

B 9-2-27

(S)

2-Dehurr if necessary

B 9-2-27

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



B 9-2-27

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

template D3798-1T1 AT9432

4.0 QC8

SECOND CHECK



Comment: SECOND CHECK

template D3798-1T1 AT9432

JWS (4)

(P70)

5.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per Q005 4.1

MD/FL

(M)

09/03/03

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD FLOOR LH

Job Number: 45578

Part Number: D3798041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



m105642



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

8:00

OVEN TEMPERATURE:

320°

FINISH TIME:

8:30

FL 09/03/04

(4)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09-03-4

8.0

D37983

Spacepod Floor Foam



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spacepod Floor Foam

845726

FF 09-03-09

(2)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- install foam as per dwg D3798 using contact cement

batch: 1111090

2- trim foam if necessary

FF 09-03-09

(2)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-03-09 (2) → 09-03-09 (2)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: 241B

9/3/4

SD

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/10

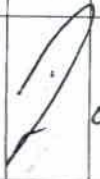


Job Completion



WLF 09-03-09

W/O: 45578

WORK ORDER CHANGES

| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
|--------|------|---|---|---------|-----|--|--|
| 090303 | 4.0 | Took 1 Per template DT9432 Powder cost coverage: ident. by |  | 0902-03 | 1 |  0903-03 |  0903-03 |
| | | | | | | | |

Part No: D3798-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries